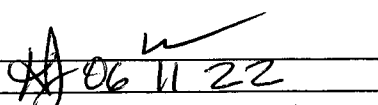


Date: Wednesday, 11/22/2006 1:39:06 PM
 User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	FLOOR PROTCTOR AFT LH
Job Number :	29643		
Estimate Number :	11228		
P.O. Number :	N/A	Part Number :	D32813
This Issue :	11/22/2006	S.O. No. :	N/A
Prsht Rev. :	NC	Drawing Number :	D3281 REV B
First Issue :	N/A	Project Number :	N/A
Previous Run :	29426	Drawing Revision :	B
		Material :	N/A
		Due Date :	1/20/2007
Written By :	Qty: 10 Um: Each		
Checked & Approved By :			
Comment :	Est Rev: A 04.07.01 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 2546
 Description: Floor Protector Aft, LH
 Possible Supplier: Delastek
 Certificate of Conformity is required

C206/11/22 (10)

2.0	D32813P	Floor Protector, Aft LH
-----	---------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)
 Floor Protector Aft, LH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage
 Ensure certificate of conformity is attached

6/7/01/22 (10)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

12/07/01/23 (10)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: _____

12/07/01/23 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: 5/10/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/22/2006 1:39:07 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT LH

Job Number: 29643

Part Number: D32813

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(10)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/05

Job Completion



U 07/01/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

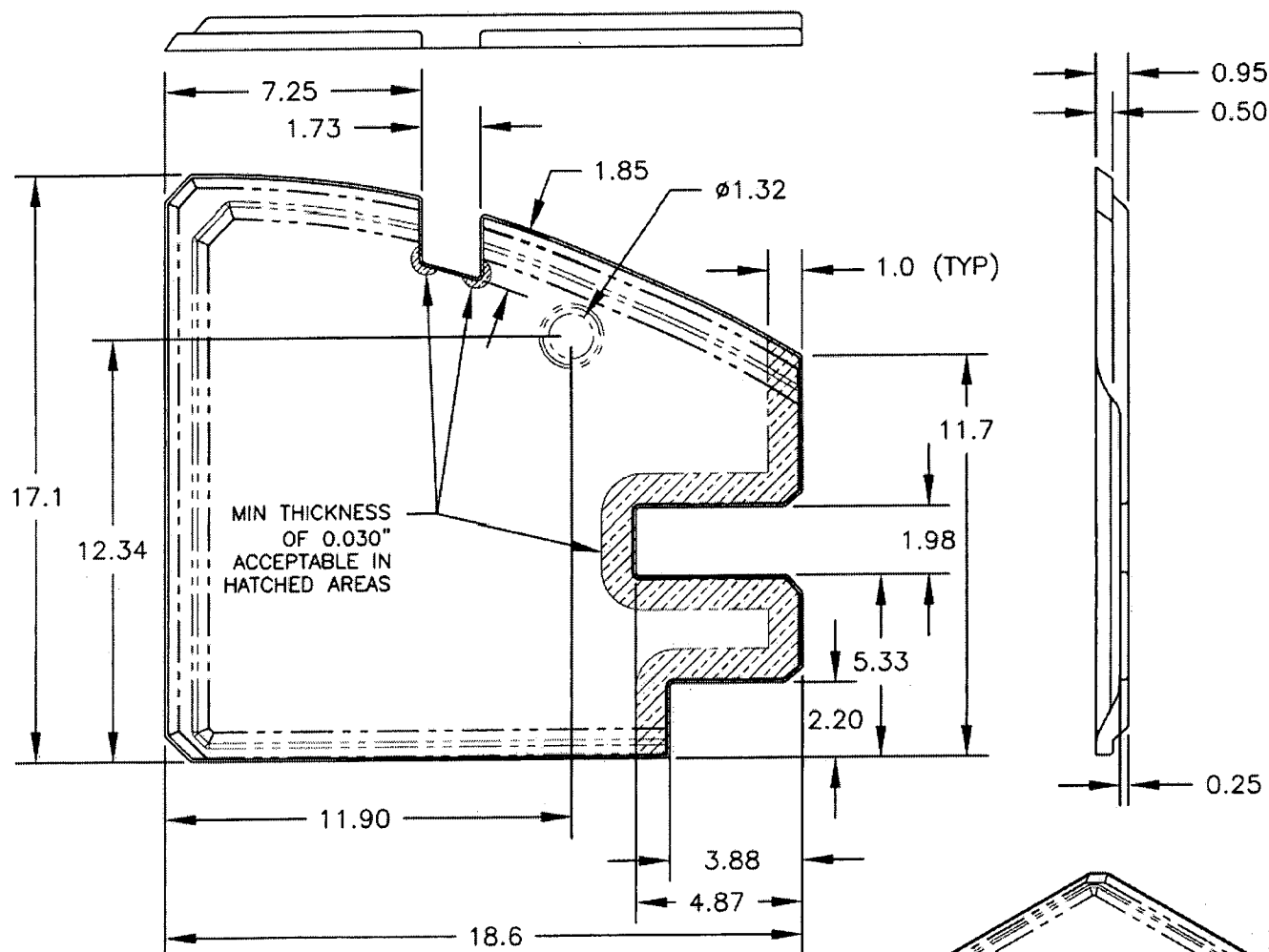
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	

**RELEASED**
05.12.01**D3281-1 FLOOR PROTECTOR, FWD LH**

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

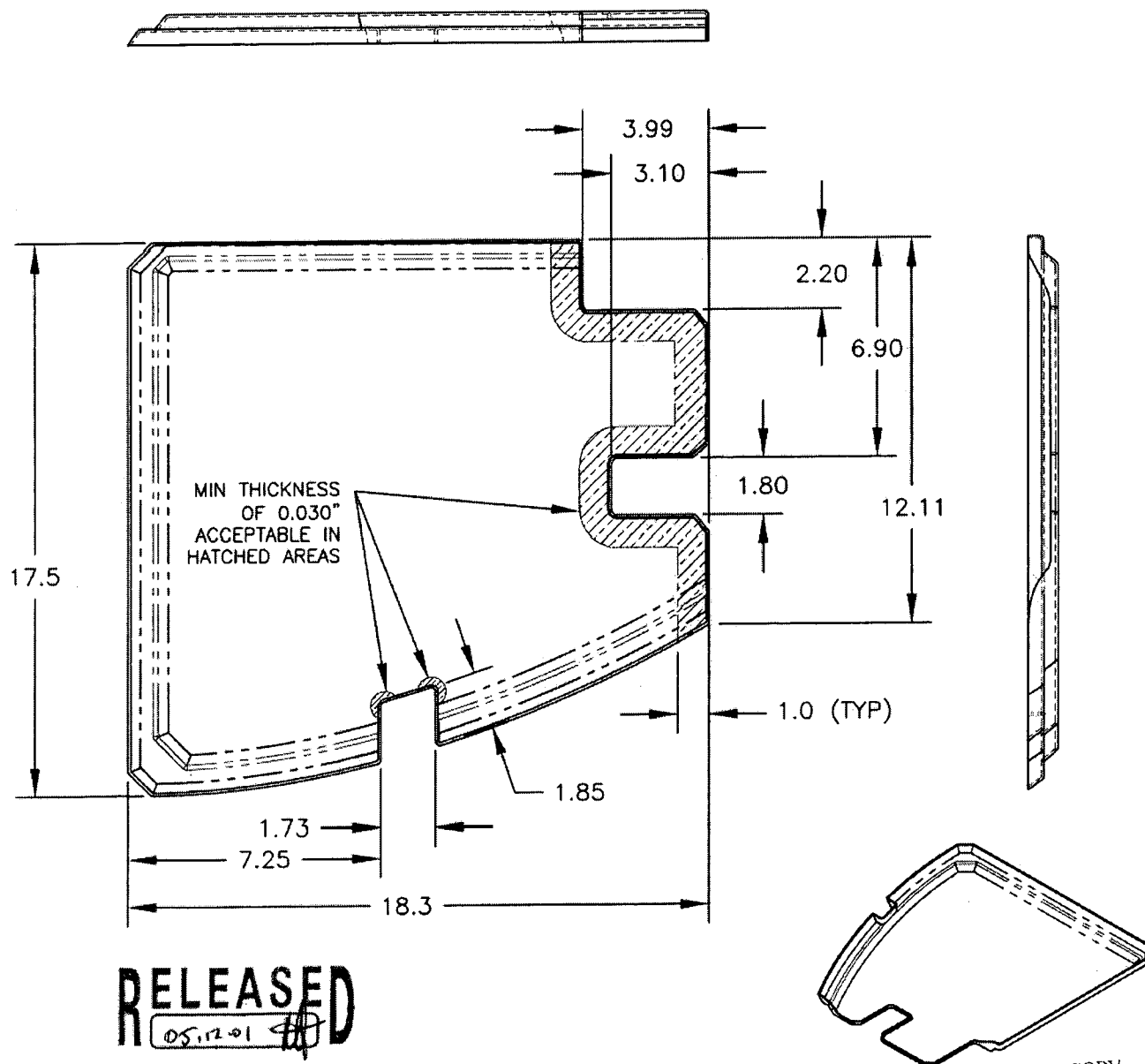
SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 29643

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DART

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
05.12.01 *[Signature]***D3281-2 FLOOR PROTECTOR, FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

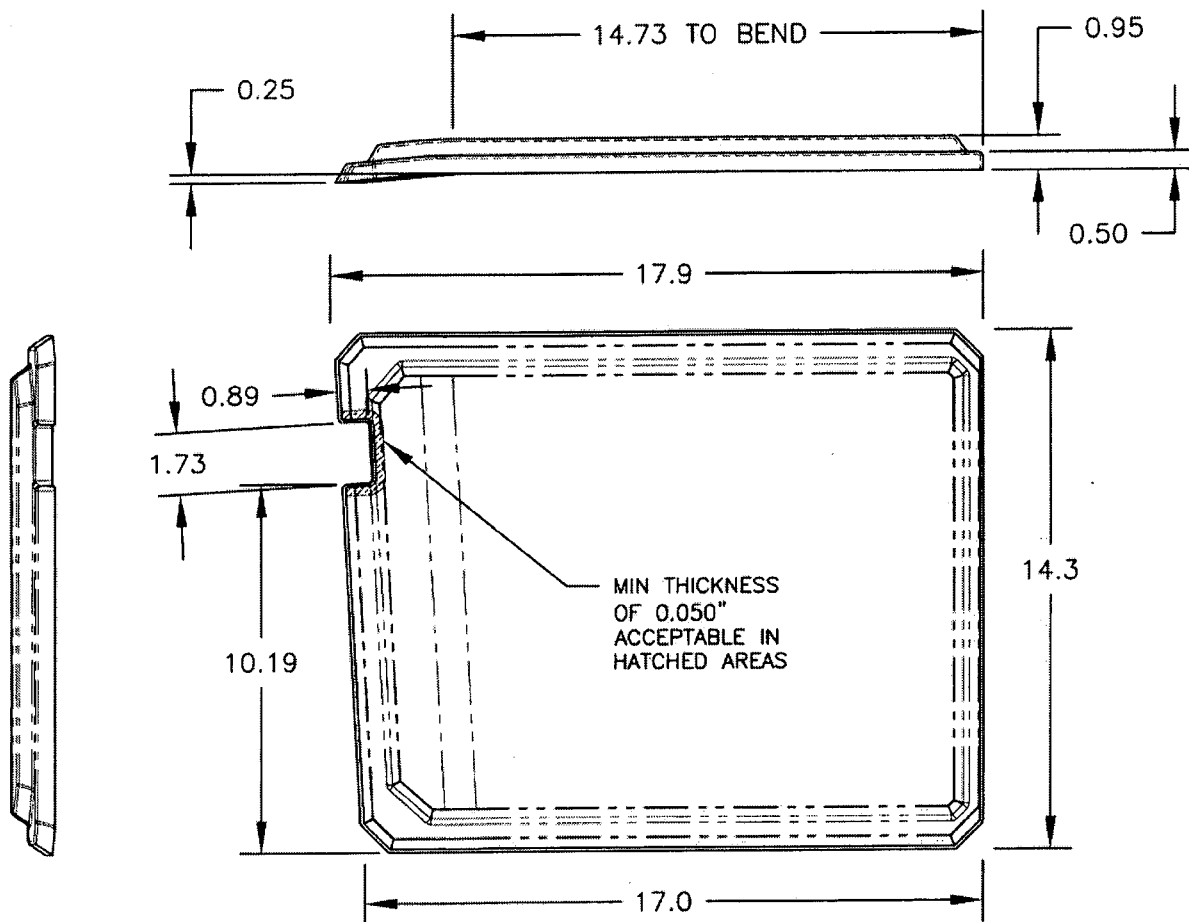
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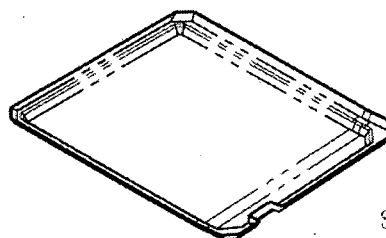
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DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



RELEASED
05.12.01. *ll*



D3281-3 FLOOR PROTECTOR. AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR. AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

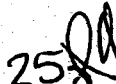
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Date: Jeudi, 2006-11-16 15:06:30
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client : DART	Dart Aerospace Ltd.	Nom Dessin : FLOOR PROTECTOR AFT, LH	
Numéro Job : 40356		Numéro Article : DKC134-0046	
Numéro Soumission : 2385		Numéro Dessin : D3281	
Numéro B.A. :		Projet Numéro : DKC134	
Cette fois : 2006-11-16	No. B.V. :	Révision dessin : B	
Prsht Rev. : NC		Matériel : F6006	
Prem. fois : - -	Type :	Date Due : 2006-12-08	Qté: 25 
Job précédente : 36894			1/6 UDM: UNITE
Écrit par :			
Vérifié & Approuvé par :			
Commentaires : N° de pièce: D3281-3			

Process Sheet Rév.: 01 Inverser le rang de la séquence
d'inspection et d'identification

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------

1.0 APL0016

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Commentair Qty.: 0.167 UNITE(s)/Unit Tc
Lexan F6006 Noir N° 700 48" x 96"

APL0016



3-5913-1

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

N° de Lot:

Bon achat: 5913

2.0 SÉCHAGE/ ANEAL

SÉCHAGE / ANEALING



Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.5000Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la charte de température le numéro de Job du matériel au séchage.

de cuisson: 5483 75484

3.0 PRÉPARATION 3

PRÉPARATION DU MATÉRIEL DART



Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 45.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 25 Date: 10-1-07 Sceau:

Quantité: Date: Sceau:



Date: Jeudi, 2006-11-16 15:06:30

Opérateur: Sylvie Hamel

Feuille de Procédé

Cliant: DART Dart Aerospace Ltd.

Nom Dessin: FLOOR PROTECTOR AFT, LH

Numéro Job: 40356

Numéro Article: DKC134-0046

Numéro Job:



Séq.: Machine ou Opération: Description :

4.0

THERMOFORMAGE2


THERMOFORMAGE DES PIÈCE DART



Commentaire Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-3 à l'aide du moule N° D3281-3T1 sur le
thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 25 Date: 10-1-07 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART



Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 2.5000Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-3 à l'aide du gabarit de trimage N° D3281-3T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 25 Date: 11-1-07 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

6.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

N° de pièce: D3281-3

N° de Job: 40356

Date de fabrication: 15-1-07

Sceau d'inspection.

Quantité: 25 Date: 15-1-07 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

Date: Jeudi, 2006-11-16 15:06:30
Utilisateur: Sylvie Hamel

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40356

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0046

Numéro Job:



Séq.: Machine ou Opération: Description :

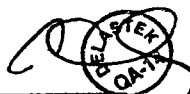
7.0 INSPECTION 3 INSPECTION PIÈCE DART



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 25 Date: 18-01-07 Sceau:



8.0 EMBALLAGE EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.2500Hrs
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton
identifiée comme suit:

N° de pièce: D3281-3

Date de fabrication: _____

N° de job: _____

Quantité: 25 Date: 18/1/07 Sceau:



Quantité: _____ Date: _____ Sceau: _____



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
*Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11498
Customer #	DART

Telephone: (819) 533-5788
Warehouse: MAIN

Bill to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:
Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-3336
Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson		
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233		
Ship date	Order Date	Our PO #	Order by	Your PO #		GST/PST #		
19/01/07	23/11/06	5021	C. Lavoie	PO00002546				
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description				
10	0	10	DKC134-0044	Floor Protect Part 1 N° D3281-1 (F6006) B29641 Selon dessin D3281 Rev.: B Job: 40353				U de M : Each
10	0	10	DKC134-0045	Floor Protect Part 2 N° D3281-2 (F6006) B29642 Selon dessin D3281 Rev.: B Job: 38794 (x2) Job: 40355 (x8)				U de M : Each
10	0	10	DKC134-0046	Floor Protect Part 3 N° D3281-3 (F6006) B29643 Selon dessin D3281 Rev.: B Job: 40356				U de M : Each
10	0	10	DKC134-0047	Floor Protect Part 4 N° D3281-4 (F6006) B29644 Selon dessin D3281 Rev.: B Job: 34176 (x1) Job: 40357 (x9)				U de M : Each

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☒ Cust. ☐ Adm. ☐ Quality ☐ Ship.

Accepted by:  12/11/07
Quality department AQ-357